

28

Date: Tuesday, 6/19/2007 2:19:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 32991		
Estimate Number	: 10330		
P.O. Number	: <u>N/A</u>	Part Number	: D2746
This Issue	: 6/19/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2746 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 32283	Material	: <u>N/A</u>
Written By	: _____	Due Date	: 7/10/2007
Checked & Approved By	: <u>7/10/06.20</u>	Qty:	30 Um: Each
Comment	: Est Rev: D 02.10.24 Re-format KJ : Est Rev: E 06-03-21 as Per Rev C JLM : Est Rev: F 06-06-12 Now On Waterjet JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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IB 07-07-05

Comment: Qty.: 0.4263 sf(s)/Unit Total : 12.7890 sf(s)
 1010/1025/A21/6aA .040" SHEET
 (M1010S20GA)
 Batch: M104921

2.0	WATER JET	FLOW WATER JET
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IB 07-07-05

Comment: FLOW WATER JET
 1-Cut as per Dwg D2746
 Dwg Rev: C
 Prog Rev: C

(30)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-07-05

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/02/06(430) counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

En 07/02/11(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 2:19:17 PM
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Drawing Name: WEARSHOE

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Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

SAD 07/07/16

30

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SAD 07/07/17

30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/18

30

8.0

POWDER COATING

POWDER COATING



M104846



30X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.L

07/07/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M 07 07 21



30

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



30X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-17

M.L 07/07/23

11.0

QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



u 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

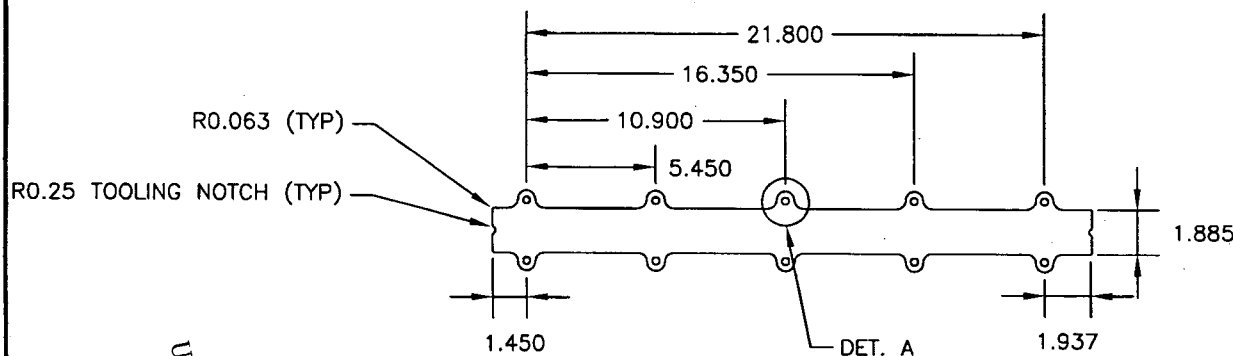
NOTE: Date & initial all entries

DART

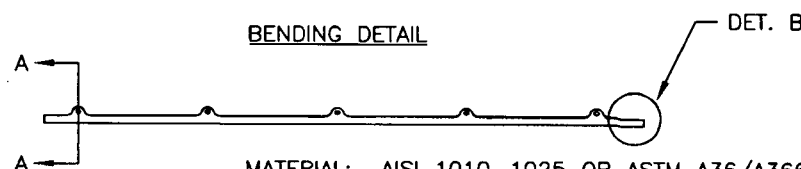
RELEASED
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
F41	F41	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2746	SHEET 1 OF 1
DATE	TITLE	SCALE	
06.01.12	WEARSHOE	1:8	
A	98.04.16	NEW ISSUE	
B	98.08.18	RE-DESIGN	
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT	

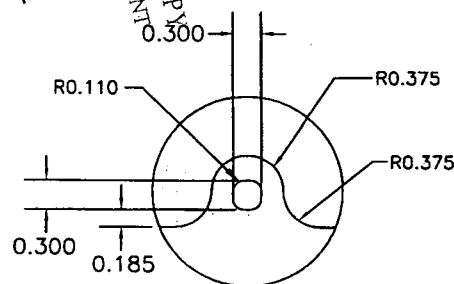
FLAT PATTERN



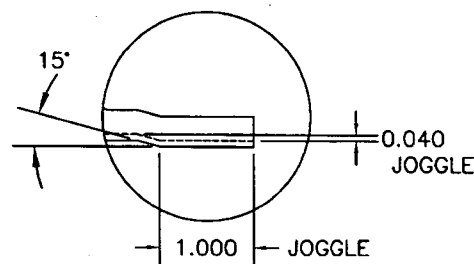
BENDING DETAIL



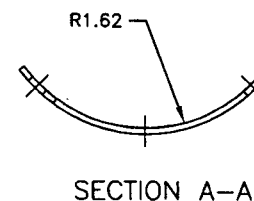
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL A



DETAIL B



SECTION A-A

NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32941